

Work Order ID 147138 -2

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June 02, 2016 2:23:58 PM

Item ID: D3414-041PHI Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 6/3/2016 Start Qty: 12.00 *12* 13 Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: SH Date: 20160602 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3414	Rev C								
100		0.00							
100									
Waterjet	Memo	0.18							
FLOW CNC Waterjet	1-Cut as per Dwg D3414-1								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									

(il) _____ De 16/06/04
 (16) _____ De 16/06/04

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Item ID: D3414-041PHI

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 6/3/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.04							
Quality Control									
130		0.02							
130									
Brake NC	Memo	0.06							
Brake NC	1-Deburr								
	2-Form using DT8254 as per Dwg D3414								
140		0.00							
140									
Large Fab	Memo	0.40							
Large Fab	1- Weld using location Jig DT9625 as per Dwg D3414								
	A/R S.S. welding rod Batch: 126011								

16

JUN 06 2016

DAS
30
9-89

16

JUN 07 2016

13

16-06-09
JBL

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Item ID: D3414-041PHI

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug

Stop ***NS2***

Start Date: 6/3/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.04				(12)	16.0610		DAS 8 9-89
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.04				(12)	16.0610		DAS 8 9-89
Quality Control									
175	Spray Painting per QSI005 4.2	0.00							
175									
SprayPaint	Memo	0.00				13			DAS 41 9-89
Spray Painting	1- PRIME INSIDE AND OUT AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: <u>134937</u>								16-7-22
	2- PAINT BLACK AS PER DWG AND QSI 005 4.2.2 USING CA8213/F3738 CAMOFLAGE BLACK PAINT BATCH: <u>135300</u>								

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Item ID: D3414-041PHI Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 6/3/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185 *185* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				<u>13</u>			DAS 38 9-89 JUL 25 2016
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>St31</u> Memo	0.00 0.20				<u>13</u>	DAS 6 9-89		JUL 25 2016
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02					DAS 21 9-89		JUL 26 2016

JUL 26 2016
 DAS
21
9-89

Picklist Print

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Work Order ID: 147138

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Parent Item: D3414-041PHI

D3414-041PHI

Parent Item Name: Lug

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	31.2230	0.155	1.86			

M304S12GA

304/316 0.100" Sheet

on 16/06/16

Location

Loc Qty

Loc Code

MAT019

31.223

m131322

31.223

D3414-3

Manufactured No

140

Each

12.0000

1

12

16-06-08
jsl

D3414-3

Lug

Location

Loc Qty

Loc Code

WA001

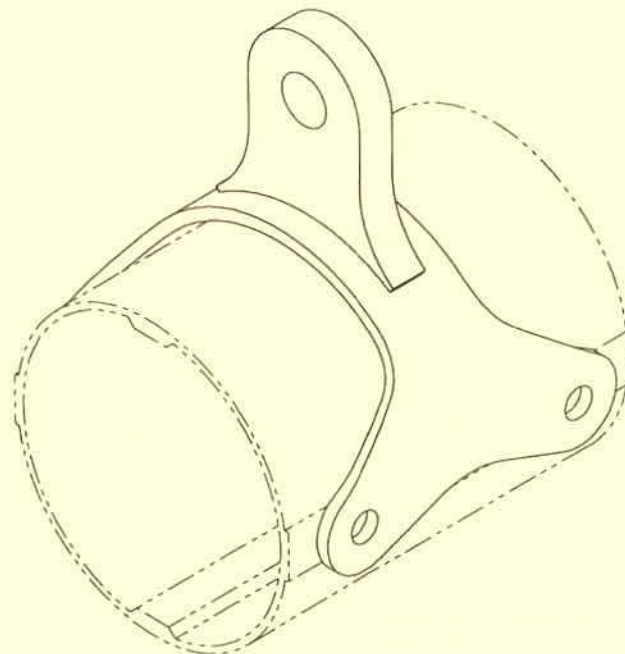
12

137638

12

B 13

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

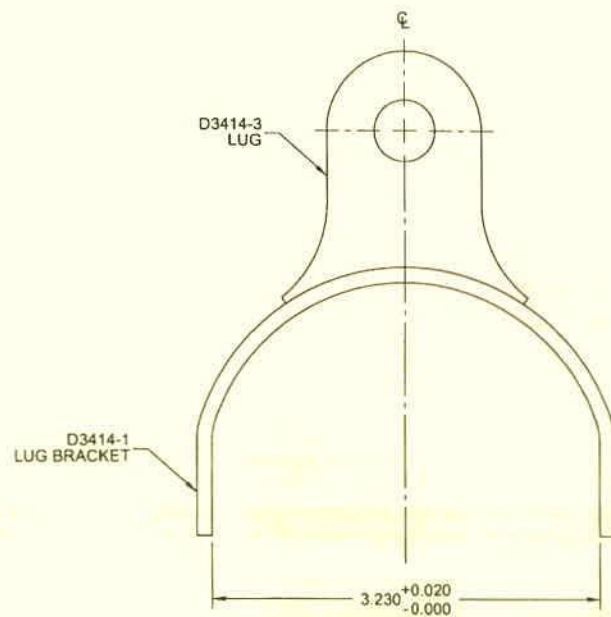
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 019 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

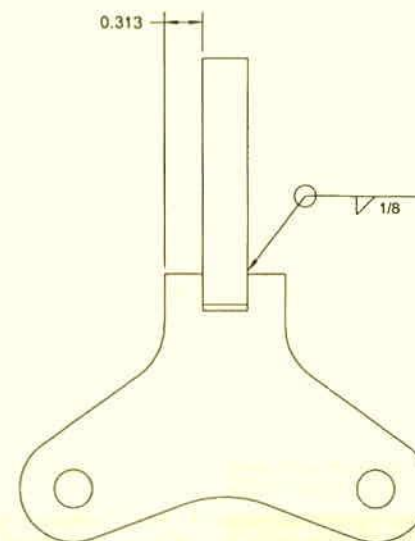
20160602
SA
147138

RELEASED
3/16/2017

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO	REL. 0
MFG. APPR	CP	D3414	SHEET 1 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

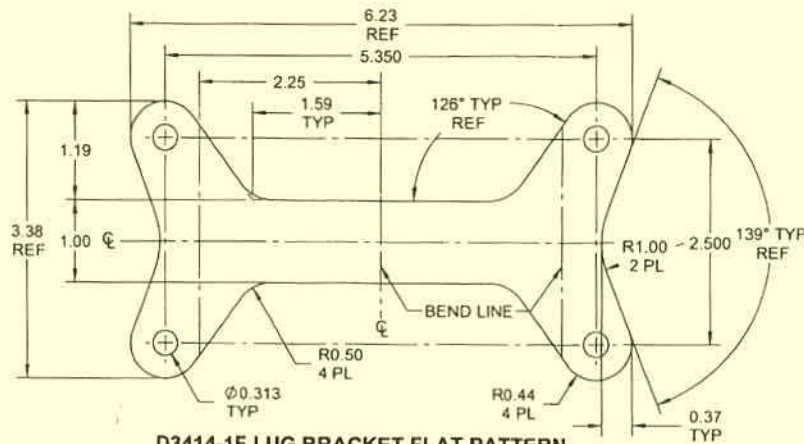


D3414-041 LUG ASSEMBLY

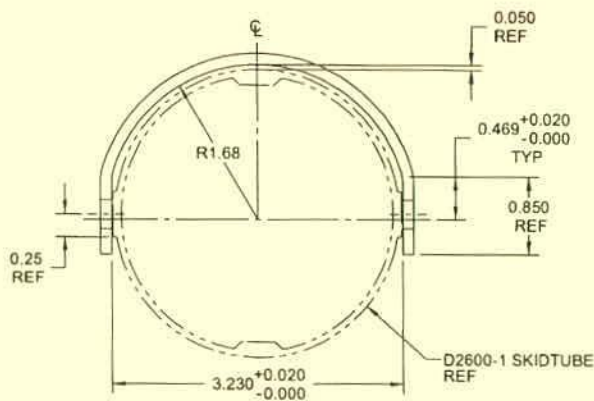


RELEASED
04/18/05

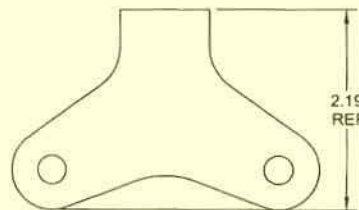
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 2 OF 3
APPROVED	CP	TITLE	SCALE
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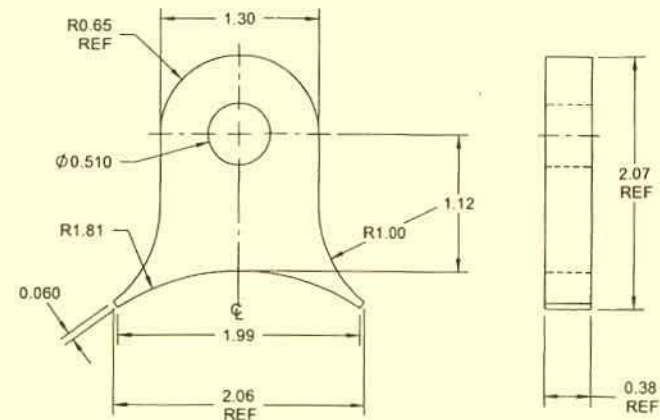
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



RELEASED
09/06/17

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 3 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
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